

IN THE CLAIMS:

1. (Currently Amended) A machining unit, ~~especially a welding cell~~, for the machining of said workpieces (2), ~~especially body parts of vehicles~~, the machining unit comprising with one or more said machining stations (15, 16) with said robots (18, 19, 20); and at least one said turning station (5), ~~which has~~ having at least two said work stations (6, 7) for carrying out different operations simultaneously, ~~characterized in that~~ the said turning station (5) ~~has~~ having at least two said multiaxially movable turning units (8, 9) arranged next to one another with said gripping tools (11, 12, 13) and with said movable turning units working areas (10), which intersect each other at the said work stations (6, 7).

2. (Currently Amended) A machining unit in accordance with claim 1, ~~characterized in that~~ wherein said turning units (8, 9) are designed as said rotatable transport robots (8, 9).

3. (Currently Amended) A machining unit in accordance with claim 1 ~~or 2~~, ~~characterized in that~~ wherein said transport robots (8, 9) are designed as stationary or unstationary, multiaxial articulated arm robots.

4. (Currently Amended) A machining unit in accordance with claim 1, ~~2 or 3~~, ~~characterized in that~~ wherein said transport robots (8, 9) are designed as heavy-load robots with a load carrying capacity of about 500 kg or more.

5. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said turning units (8, 9) carry said replaceable gripping tools (11, 12, 13) for said different workpieces (2), ~~especially corresponding to~~ different body models.

6. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein a plurality of said gripper storage units (14) are arranged in said working area (10) of said turning units (8, 9).

7. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said gripping tools (11, 12, 13) are designed as geometry grippers, which hold said workpiece (2) in a defined position.

8. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein one said work station (6) is designed as a workpiece pick-up and said other work station (7) as a joining site, ~~preferably a welding site~~.

9. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said turning station (5) with at least one said work station (6, 7) is connected in said transfer direction (16) [~~sic - Tr.Ed.~~] to at least one said machining station (15, 16) equipped with one or more said robots (18, 19, 20), wherein said work

5 station(s) (6, 7) is/are located in said working area (10) of said robots.

10. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said machining station (15, 16) has at least one ~~said~~ workpiece storage unit (22) for ~~said~~ a replaceable robot tools (21) in said working area (10) of said robots (18, 19, 20).

11. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said machining station (15, 16) has one or more ~~said~~ component feeds (23, 24, 25) in said working area (10) of said robots (18, 19, 20).

12. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said machining station (15, 16) has one or more ~~said~~ stationary machining devices (26) in said working area (10) of said robots (18, 19, 20).

13. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein said machining unit (1) has a manual or automatic workpiece feed means (3) at the inlet of ~~said~~ transfer line (17) and a manual or automatic workpiece storage unit (4) at the outlet.

14. (Currently Amended) A machining unit in accordance with ~~one of the above claims~~

claim 14, characterized in that wherein said workpiece feed means ~~(3)~~ and/or said workpiece storage unit ~~(4)~~ forms a work station ~~(6)~~ of a turning station ~~(5)~~.